

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 82.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018800**Date Inspected:** 11-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1330**Contractor:** Westmont Industries**Location:** Santa Fe Springs, CA.**CWI Name:** Ruben Dominguez**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Travelers**Summary of Items Observed:**

The Quality Assurance Inspector Sean Vance arrived on site at Westmont Industries (WMI) in Santa Fe Springs, CA, to randomly observe the in process welding, QC inspection and non-destructive testing of the Travelers.

Upon the arrival of the QA Inspector, the following observations were made:

Traveler Test Rack

On this date, the QA Inspector observed WMI production personnel performing fitting, welding and cutting activities on various assemblies for the Traveler Test Rack.

SAS-EB Traveler**Fixed Stairs Section**

On this date, the QA Inspector observed Westmont Industries (WMI) production welder, Mr. Jose Rodriguez (WID # 3031) continuing to perform grinding activities on the previously completed fillet and flare groove welds. The QA Inspector observed that the grinding being performed appeared to be on the areas which were previously marked by SE QC Inspector Ruben Dominguez. These areas appeared to be excessive weld reinforcement and weld spatter, which appeared to be non conforming to the requirements of AWS D1.1 2002 Structural welding Code-Steel. During observation, the QA Inspector observed that Mr. Dominguez appeared to be utilizing a mechanical grinder to break the edges of connector plate material. Additionally, the QA Inspector observed Mr. Rodriguez performing Flux Core Arc Welding (FCAW) activities in various positions on random areas of the previously completed fillet and flare groove welds. The QA Inspector observed that these areas appeared to be underfill, which had been previously marked by SE QC Ruben Dominguez, during Visual Testing.

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Lower Truss Section

On this date, the QA Inspector observed Westmont Industries (WMI) production welder, Mr. Eutimo Lopez (WID # 3035), continuing to perform Flux Core Arc Welding (FCAW) activities on the previously fit Frame assemblies, identified as 12-A240, 13-B240, 7-A225, 8-A226 and 9-A230. The QA Inspector observed throughout the shift, that the FCAW was being performed in various positions, on the connector plate and Tube Steel (TS) material fillet and flare groove welds.

E2/E3-EB Traveler.

On this date, the QA Inspector observed WMI production personnel, Mr. David Mora performing layout and cutting activities on material, for the E2/E3-EB Travelers. The QA Inspector observed Mr. Mora utilizing a vertical bandsaw to perform the cutting operations. The material appeared to be identified as .1875" (5 mm) x 2" (51 mm) x 2" (51 mm) square Tube Steel (TS). Once the material was cut to length, the QA Inspector observed Mr. Mora identifying each piece of material, per the drawing Bill of Material list. The QA Inspector then observed Mr. Mora place the material on a wooden pallet, nearby the work area.

On this date, the QA Inspector observed WMI production welder Mr. Juan Jimenez (WID # 3059) continuing to perform Flux Core Arc Welding (FCAW) welding activities on the Frame Assembly identified as 9-A332, per the shop drawings. The QA Inspector observed throughout the shift, that the FCAW was being performed in various positions, on the connector plate and Tube Steel (TS) material fillet and flare groove welds.

On this date, the QA Inspector observed Westmont industries (WMI) production welder, Mr. Charles Newton (WID # 3200) performing fitting and Flux Core Arc Welding (FCAW) activities on material, for the E2/E3-EB Traveler.

The QA Inspector observed that the material appeared to be identified as Stair Risers to Stair Braces, for the Elevating Platform Assembly. The QA Inspector observed that Mr. Newton was performing the FCAW in various positions and the welds appeared to be designated as fillet and flare groove.

On this date, the QA Inspector observed Westmont industries (WMI) production welder, Mr. Mike Ruiz (WID # 3155) performing fitting and Flux Core Arc Welding (FCAW) activities on material, for the E2/E3-EB Traveler. The QA Inspector observed that the activities were being performed on Tube Steel (TS) material on the Frame Assembly identified as 7-A327, per the shop drawings. The QA Inspector observed that Mr. Ruiz was performing the FCAW in various positions and the welds appeared to be designated as fillet and flare groove.

The QA Inspector randomly observed that Smith-Emery QC Inspector Ruben Dominguez was present, during the above mentioned welding and fitting activities. During random observation, the QA Inspector observed that the applicable WPS's and copies of the shop drawings, appeared to be located near each work station, where the above mentioned welding and fitting activities were being performed. The QA Inspector randomly verified that the consumable material, utilized during the welding appeared to be in compliance with the applicable WPS and that the above mentioned welders were currently qualified for the applicable process and position of welding. The QA Inspector randomly observed QC Inspector Dominguez verifying the in-process welding parameters, including voltage, amperage, pre-heat and travel speed and the parameters appeared to be in compliance to the applicable WPS.

Summary of Conversations:

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As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Vance,Sean	Quality Assurance Inspector
Reviewed By:	Edmondson,Fred	QA Reviewer
